

Date: Wednesday, 28/05/2008 1:22:47 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |  |                           |                       |
|------------------------------------|--|---------------------------|-----------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> :     | 205 SKIDTUBE "I" BEAM |
| <b>Job Number</b> :                | 39538  |                           |                       |
| <b>Estimate Number</b> :           | 10346  |                           |                       |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D2596                 |
| <b>This Issue</b> :                | 28/05/2008   | <b>S.O. No.</b> :         |                       |
| <b>Prsht Rev.</b> :                | NC   | <b>Drawing Number</b> :   | D2596 REV D           |
| <b>First Issue</b> :               | //   | <b>Project Number</b> :   | N/A                   |
| <b>Previous Run</b> :              | 39458  | <b>Drawing Revision</b> : | D                     |
|                                    | <b>Type</b> :  | <b>Material</b> :         |                       |
|                                    | SKIDTUBES  | <b>Due Date</b> :         | 06/06/2008            |
| <b>Written By</b> :                |  | <b>Qty:</b>               | 5                     |
| <b>Checked &amp; Approved By</b> : | JLD 08.5.28  | <b>Um:</b>                | Each                  |
| <b>Comment</b> :                   | Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D<br>M<br>Est Rev:E 07-07-09 Incorporated DEO 9183 JLM |                           |                       |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                         |
|-----|-----------|-------------------------|
| 1.0 | D25003100 | Ext'n - 'I' Beam Web 4" |
|-----|-----------|-------------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick;

|                                     |     |             |             |                 |
|-------------------------------------|-----|-------------|-------------|-----------------|
| <input checked="" type="checkbox"/> | Qty | Part Number | Description | Batch           |
|                                     | 1   | D2500-3-100 | Extrusion   | 33940 SL 8-5-28 |

|     |             |                       |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

74 8-5-28

|     |                 |                            |
|-----|-----------------|----------------------------|
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

ANM 8-5-29

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

08-05-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39538

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SKID TUBE CELL

AWM 8-5-29

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

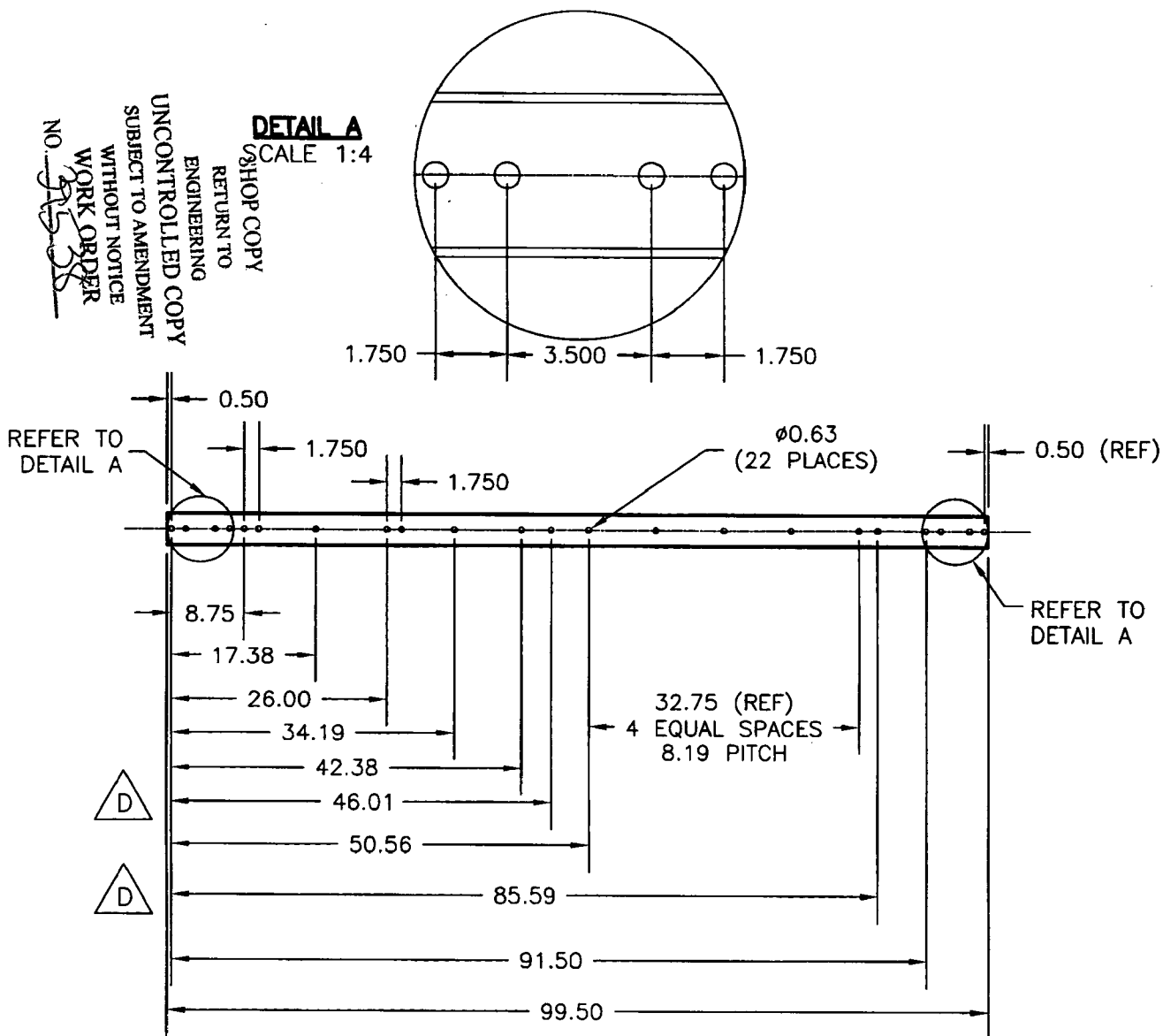
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



RELEASED  
07 DEC 28

|          |             |                             |  |
|----------|-------------|-----------------------------|--|
| DESIGN   | DRAWN BY    | DART AEROSPACE LTD          |  |
| CHKD     | APPROVED    | HAWKESBURY, ONTARIO, CANADA |  |
| DATE     | DRAWING NO. | REV. D                      |  |
| 07.04.17 | D2596       | SHEET 1 OF 1                |  |
|          | TITLE       | SCALE                       |  |
|          | 205 WEB     | 1:20                        |  |
| A        | 96.09.16    | NEW ISSUE                   |  |
| B        | 97.07.23    | Ø0.63 HOLE WAS Ø0.56        |  |
| C        | 98.09.14    | INCORPORATED DEO 9097       |  |
| D        | 07.04.17    | INCORPORATED DEO 9183       |  |



DETAIL A  
SCALE 1:4

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 91535

#### D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries